

3M™ Scotchkote™ Purple Patch Compound 323

Data Sheet

Product Description

3M™ Scotchkote™ 323 Purple Patch Compound is an ambient temperature cure, two-part system designed to protect metal, concrete and other surfaces from corrosion and deterioration. Scotchkote 323 Purple Patch Compound is the patch material color matched to 3M Scotchkote 3M™ Scotchkote™ Fusion Bonded Epoxy 426.

Features

- Excellent edge coverage
- No solvents needed
- 100% solids
- Application by cartridge
- Excellent adhesion
- Can be applied to substrate as cold as 41°F / 5°C
- VOC for parts A and B as mixed 12 g/L

General Application Steps

1. Remove oil, grease and loosely adhering deposits.
2. Abrasive blast clean the surface to near-white in accordance with NACE No.2/SSPC-SP 10 near-white metal, ISO 8501-Sa2.5.
3. Ensure the abraded surface is cleaned of debris with the use of an air blaster or a clean lint free cloth.

4. Within 4 hours of blasting as per the above cleaning process and with the metal above 41°F/5°C, apply Scotchkote 323 purple patch compound at the specified thickness.
5. Allow to cure.
6. Visually or electrically inspect the coating for defects.
7. Repair all defects using same material.

*To prevent the formation of rust or oxide, coat as soon as possible after cleaning. For maximum protection, the coating must have direct contact with the metal or parent coating surface.

Repair of Fusion Bonded Epoxy Coating

Scotchkote coating requiring limited repair (scrapes, scars, coating imperfections or other minor defects) should be cleaned to remove dirt, scale and damaged coating by sanding or other suitable means. Feather the adjacent coating and remove all dust by wiping. Next, apply the coating to the clean surface. The freshly coated area should be allowed to properly cure prior to handling and storage. Cure can be accelerated with heat.

Multiple Coats

Scotchkote 323 Purple Patch Compound has been formulated for single coat applications. If additional coats are required, for example edge coverage, apply the additional coats within three hours of the initial coat. This coating may be applied in any thickness consistent with producing an acceptable surface finish.

Typical Properties

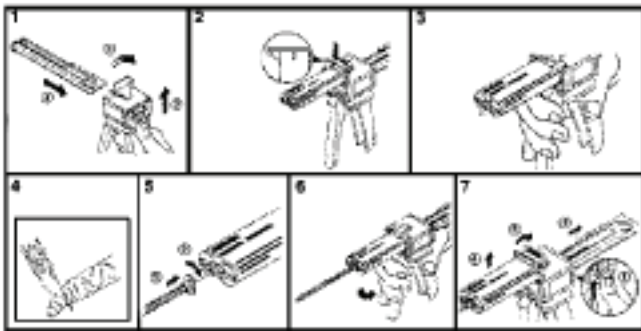
Property	Typical Value
Color	Purple
Mix Ratio	2 A to 1 B by volume 70.8% : 29.2% by weight
Shelf Life, unmixed, closed container	24 months
Viscosity in CPS	Part A: 120,000 Part B: 20,000
Specific gravity mixed	1.34
Coverage	50 ml cartridge yields approximately 360 sq. in. @ 8.5 mils 450 ml cartridge yields approximately 22 sqft @ 8.5 mils



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Property	Test Description	Typical Value			
Shyodu Gel Time (approximate pot life)	200 gm mass	75°F/24°C	17 min		
		104°F/40°C	11 min		
Dry to Touch Time	ASTM D1640 clause 7.5.2	41°F/ 5°C	7 hrs		
		75°F/24°C	1 hrs 45 min		
		122°F/50°C	26 min		
Dry to Handle Time	ASTM D1640 clause 7.7.1	41°F/ 5°C	8 hrs		
		75°F/24°C	2 hrs 39 min		
		122°F/50°C	39 min		
Cathodic Disbondment (steel grit blasted plates laboratory applied; results may vary depending on blast media)	CSA Z245.20-98 clause 12.8	149°F/65°C	3.5V	24 hrs	4.9 mmr
		149°F/65°C	1.5V	48 hrs	5.5 mmr
		149°F/65°C	1.5V	28 days	7.5 mmr
		176°F/80°C	1.5V	14 days	6.4 mmr
		176°F/80°C	1.5V	28 days	6.6 mmr
Adhesion	CSA Z245.20-98 clause 12.14	203°F/95°C	24 hrs	Rating 1	
		167°F/75°C	48 hrs	Rating 1	
		167°F/75°C	28 days	Rating 1	
Flexibility	CSA Z245.20-98 clause 12.11	68°F/20°C	0.7	*/PD	
		32°F/ 0°C	0.7	*/PD	
Abrasion Resistance	ASTM D 4060-95 CS-17 wheels 1000 g load 5000 cycles wheels resurfaced every 500 cycles	0.325 g loss			

Scotch 323 Patch Compound Applicator



Handling and Safety Precautions

Read all Health Hazard, Precautionary, and First Aid statements found in the Material Safety Data Sheet, and/or product label of chemicals prior to handling or use.

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